

Work Order ID 62823

Friday, October 08, 2010 12:47:21 PM

Page 1

Item ID: D3319-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearplate

Start Date: 10/8/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3319

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319

☐ Dwg Rev:

B

☐ Prog Rev:

B

☐ 2-

Deburr if necessary

1010.056

B 10-10-13



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-10-13

120

QC8- Inspect parts - second check

0.00



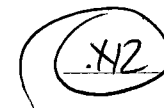
QC

Memo

0.00

Quality Control

5.10.10.14



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62823

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Page 2

Item ID: D3319-1

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Item Name: Wearplate

Start Date: 10/8/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
		N/A							
140 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1- Form using DT8326 & DT8261 as per Dwg D3319Rev: <u>B</u> <input type="checkbox"/> 2- Form flat on press using DT8776 block								
		SB 10/10/19							
150 	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control						12			10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

8755

Work Order ID 62823



Page 3

Friday, October 08, 2010 12:47:21 PM

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 10/8/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



Large Fab

Large Fab

Large Fab

Memo

1- Layout weld location as per Dwg D3319 using jig D3319-1T3-2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: B Qty Part
 Number Description Batch A/R N/A 7560
 Hardcoat Rod 228 M112507

0.00

0.00

Cpl 10.10.20

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

12 10/10/20

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

12 10/10/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 62823

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Page 4

Item ID: D3319-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 10/8/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

10-10-22



Powdercoat

M112588

0.00

12

Powder Coating

Memo

START TIME:

8:35

OVEN TEMPERATURE:

320° FINISH TIME:

9:05

200

QC3- Inspect Part Finish

0.00

10/10/22



QC

Memo

0.00

12

Quality Control

210

Packaging

0.00



Packaging

Memo

0.00

10/10/22

120

Packaging

Identify on inside surface using a permanent fine point marker with the following: ☐ TCCA-PDA, Dart Aerospace Ltd. ☐ P/N: D3319-1, B/N: BXXXXX ☐ For Product Eligibility see PDA05-18 ☐ and Stock ☐ Location: 472

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 62823

Page 5

Friday, October 08, 2010 12:47:21 PM

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Item Name: Wearplate

Start Date: 10/8/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/22 *[Signature]*
ME
10-10-22

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:47:25 PM

Page 1

Work Order ID: 62823



Parent Item: D3319-1



Parent Item Name: Wearplate

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B□05.10.14□Added step 9, dwg rev B □KJ/EC□
IPP Rev:C Now on Waterjet 06-10-26 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S18GA

Purchased

No

100

sf

5.4585

0.628

6.610526

7.6



10-10-13

1010/1025 SHEET .048

Location

Loc Qty

Loc Code

MAT19

5.45853

114225

5.45853

114225

(12)

SEE ATTACHED email
Last page.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62823
Description: Wearplate		Part Number:	D3319-1
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.984	+/-0.010	4.981	X		V ISO2	
1.600	+/-0.010	1.604	X		V	
2.660	+/-0.010	2.666	X		V	
3.190	+/-0.010	3.196	X		V	
3.563	+/-0.010	3.560	X		V	
4.712	+/-0.010	4.707	X		V	
0.60	+/-0.030	.604	X		V	
10.576	+/-0.010	10.570	X		V PRO ISO2	
11.942	+/-0.010	11.941	X		V PRO	
18.09	+/-0.030	18.09	X		T	
Ø0.316 x 0.546	+0.006/-0.001 x +/-0.010	.316 X .546	X		V	
Ø0.316 x 0.670	+0.006/-0.001 x +/-0.010	.316 X .674	X		V	
Ø0.190	+0.005/-0.001	.193	X		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10+10-13	Date: 10/10/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.31	New Issue	KJ/JLM	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

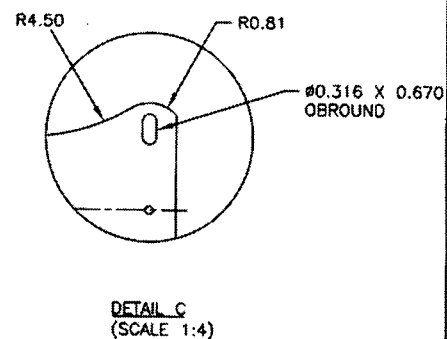
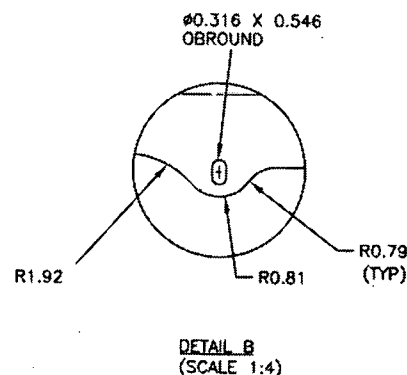
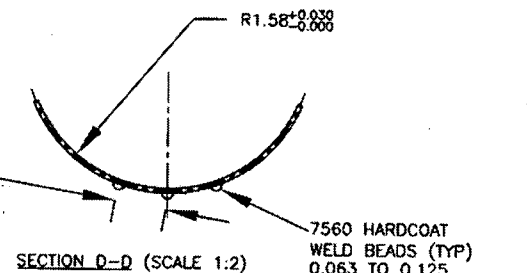
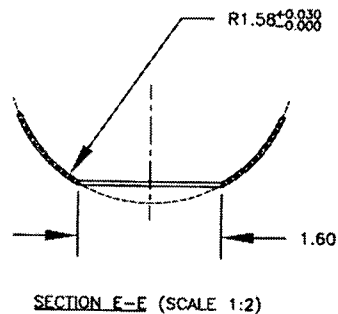
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN		DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.		REV. B	
05.06.06	05.06.06	D3319		SHEET 1 OF 5	
DATE		TITLE		SCALE	
05.06.06		WEARPLATE		1:8	
A	04.09.24	NEW ISSUE			
B	05.06.06	WIDEN HOLES,REDUCE WIDTH -3/-5/-7			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

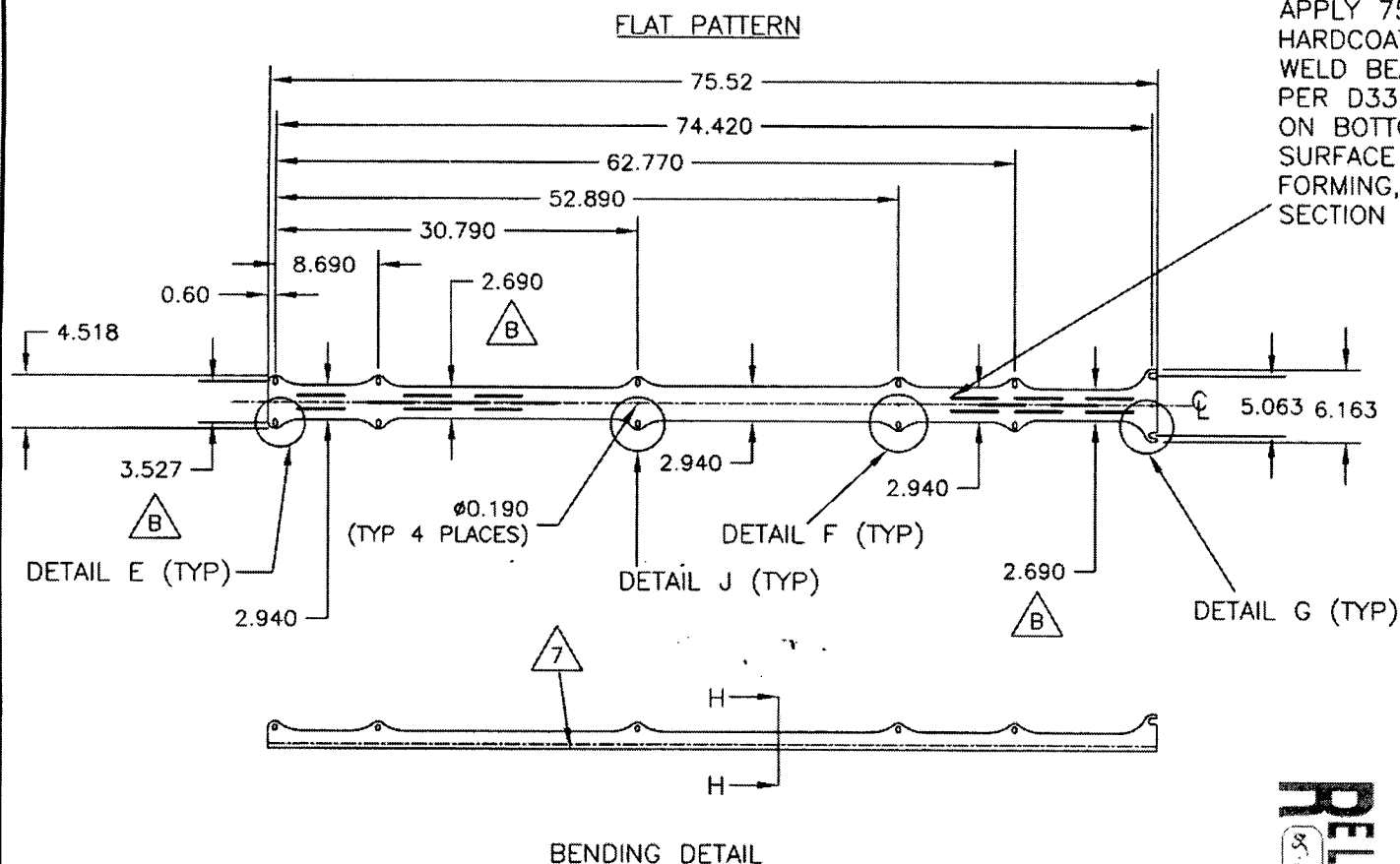
NOTE: Date & initial all entries

DART

W/O 42823

DESIGN	DH	DRAWN BY	DH	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
			WEARPLATE	SHEET 2 OF 5
				SCALE 1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
85-07-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

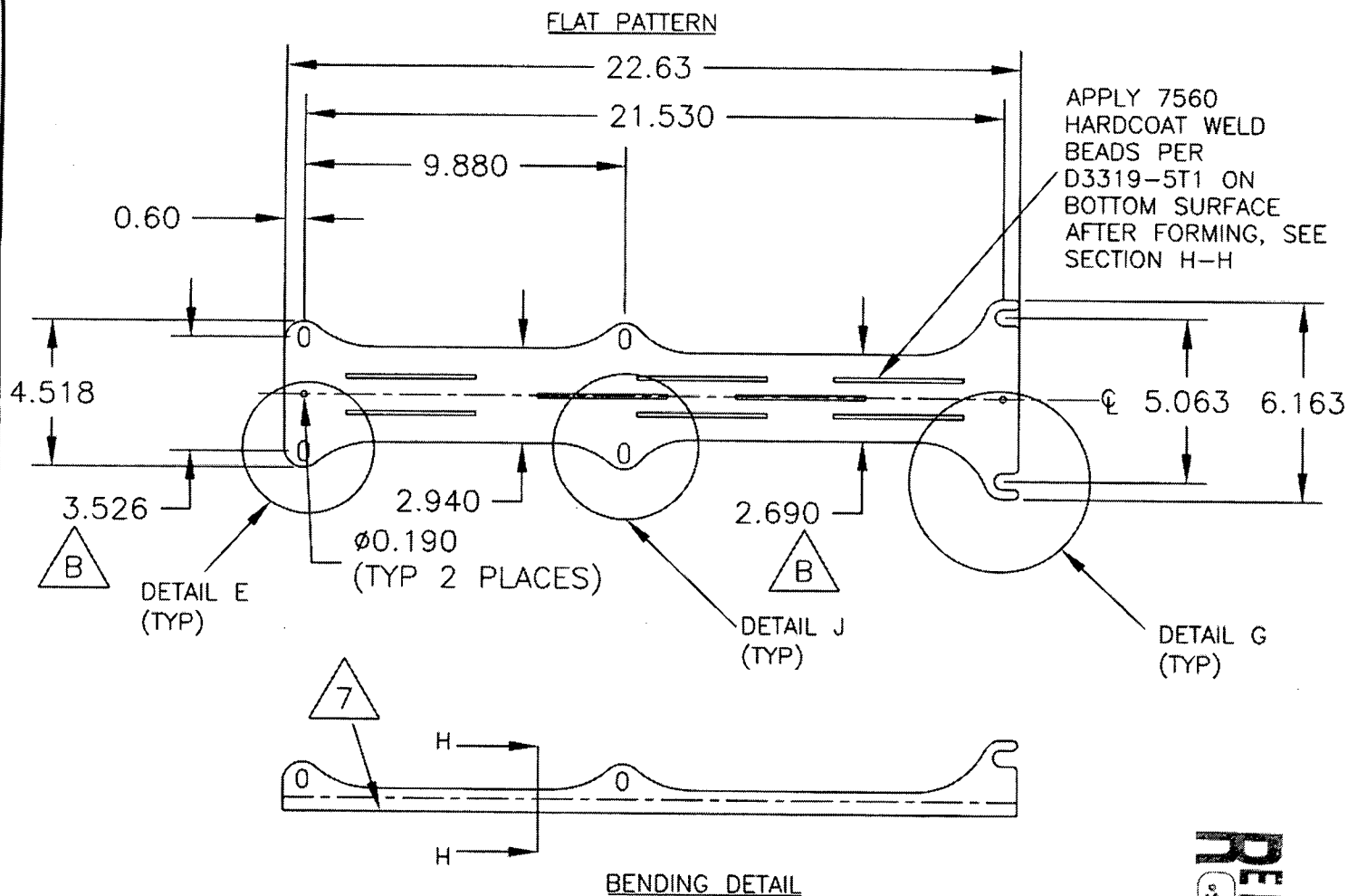
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

arbo 42823

DESIGN	D41	DRAWN BY	D41	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. B
				D3319	SHEET 3 OF 5
DATE				TITLE	SCALE
05.06.06				WEARPLATE	1:5

05-09-30



D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

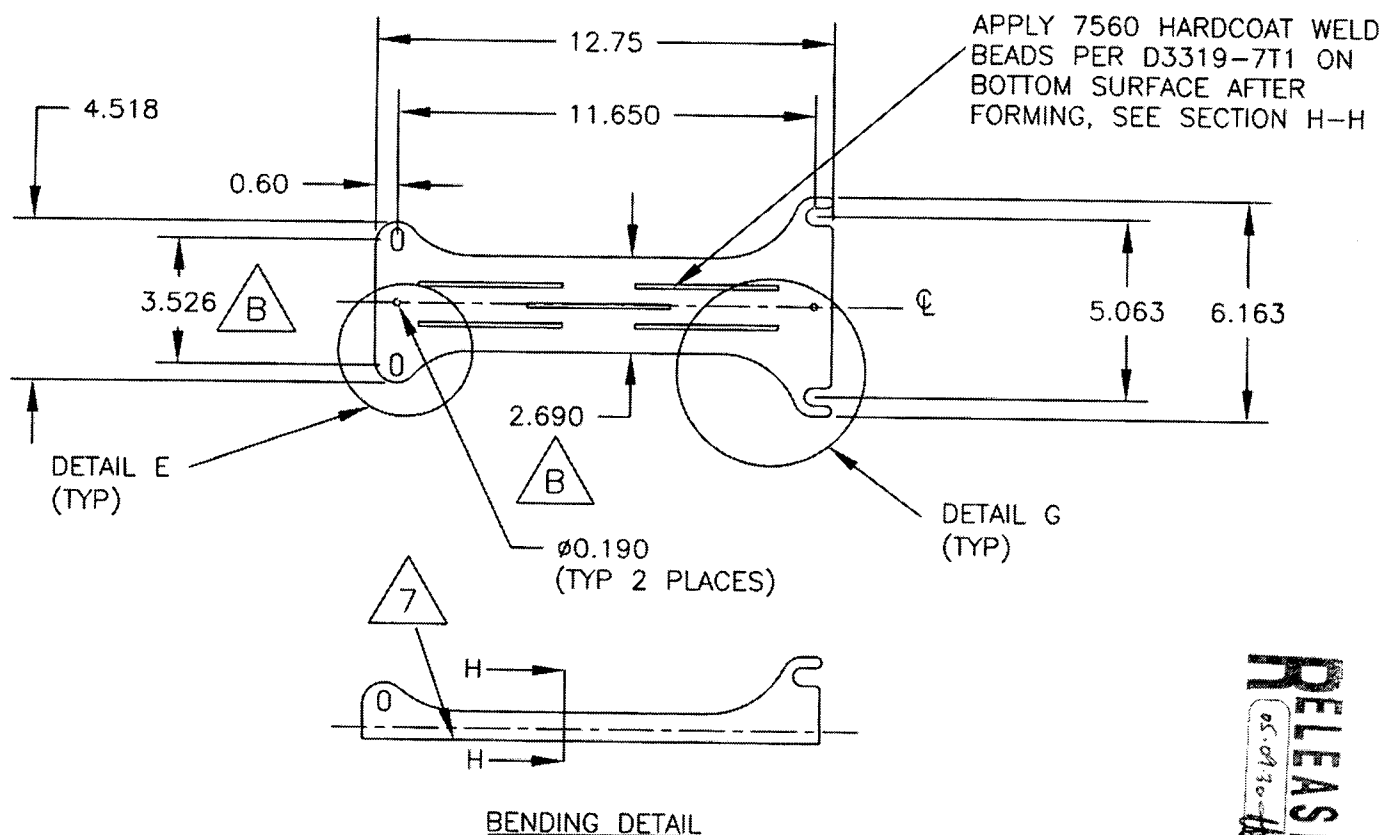
DART

u/s 42823

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
			WEARPLATE	SHEET 4 OF 5
				SCALE 1:5

RELEASED
05.09.10

FLAT PATTERN



D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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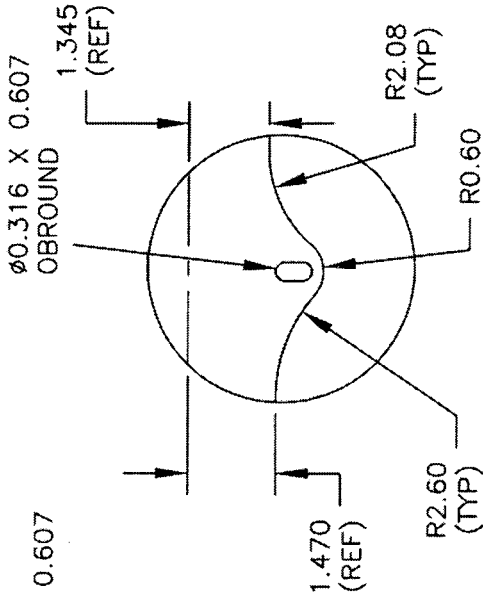
NOTE: Date & initial all entries



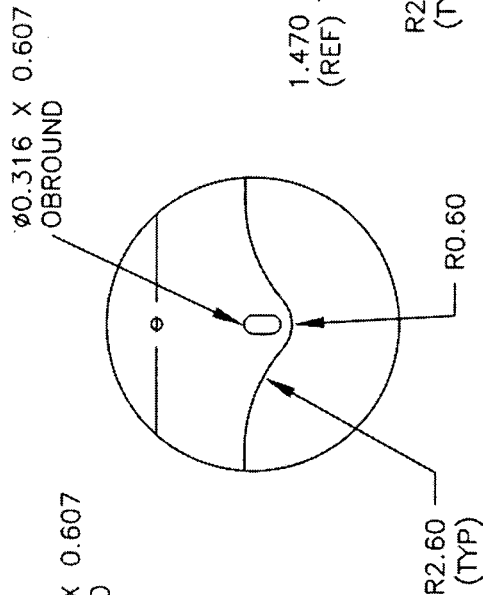
W/6 62823

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DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

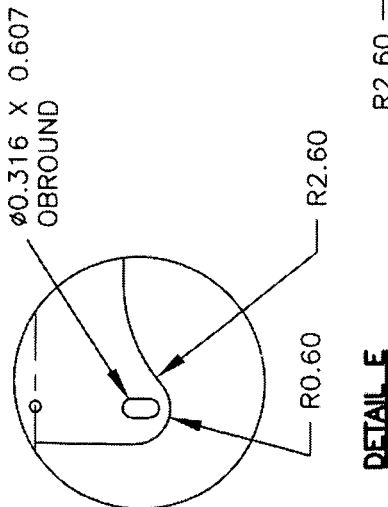
RELEASED
05-09-30



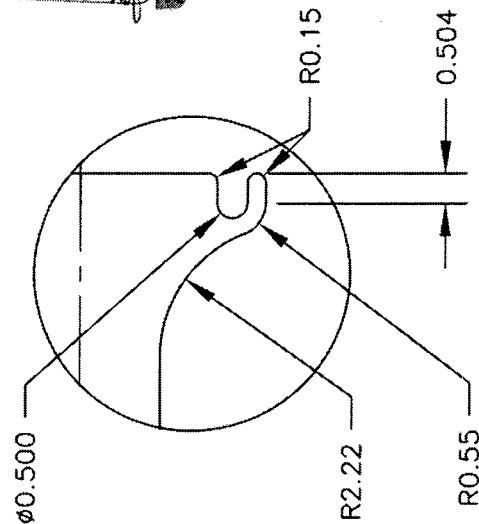
DETAIL J



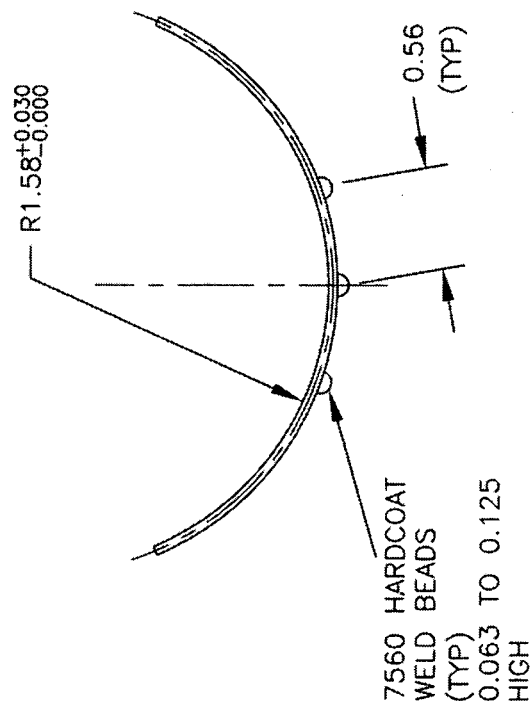
DETAIL E



DETAIL F



DETAIL G



SECTION H-H
(SCALE 1:1)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Chantal Lavoie

From: David Shepherd [dshepherd@dartaero.com]
Sent: October 12, 2010 10:57 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Chantal Lavoie'
Subject: RE: M1010-S material

Chris,

It is acceptable to use this material for wearplates.
The minimum allowables are for ground handling lugs.

Thanks,
David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Tuesday, October 12, 2010 11:45 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Chantal Lavoie'
Subject: M1010-S material

- David,

RE: incorrect material (commercial grade) in stock for 1010-1025 steel

Chantal is trying to get the proper material in, but is still trying to source the stuff. In the meantime they need to make a bunch of OEM wearplates. Can we use the existing (commercial) material?

The material in question is made to ASTM 1008, AISI 1010 CS (commercial steel) grade with a "typical" tensile strength 20-40 ksi. Given the nature of the wearplates, there would be no danger in using the material; however I don't have authority to make such a deviation.

-Chris

No virus found in this incoming message.
Checked by AVG - www.avg.com
Version: 8.5.448 / Virus Database: 271.1.1/3187 - Release Date: 10/12/10 06:34:00

10/13/10